Date: Monday, 1/16/2006 4:15:39 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 25511		
Estimate Number	: 10268		
P.O. Number	: N/A	**Part Number**	: D350636014
This Issue	: 1/16/2006 **S.O. No.** : N/A	**Drawing Number**	: D2750 REV C1
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: C1
Previous Run	: 25096	**Material**	: N/A
Written By	: SEE COMMENT BELOW	**Due Date**	: 2/10/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:H 05.12.08 Rearranged procedure steps EC		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-014 CHG 001 DH 06/02/24

2.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B25384 PM 06-02-21 (1)

3.0	D2744	Fwd Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2744	Cap	B23098 BE 06-02-22 (1)

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750Mark cut line using Jig DT 8150. Deburr end PM 06-02-21 (1)

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150.Second side of Detail B to be Drilled using DT 8330 PM 06-02-21 (1)
**********Drill last hole using Dt 8820 locating off last hole drilled**********************

3-Open up holes for Detail B, D and 2 aft 0.500" Æ holes to finished size as per Dwg D2750 and DEO 9133Do not open any 0.625" Æ holes to finished size PM 06-02-21 (1)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:15:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511 **Part Number:** D350636014

Job Number:

Seq. #:	Machine Or Operation:	Description :

4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-4),mark Fwd end for cutting using Drill Jig DT8150,then drill both sides. Pm 06-02-21 (1)

5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330 Pm 06-02-21 (1)
Make sure that wearplate holes are on bottom of tube***

6-Open holes to .500" as per detail "B&C" Pm 06-02-21 (1)

7-Open holes to .375"mas per detail "D" Pm 06-02-21 (1)

8-Cut fwd end of tube as per Dwg D2750 Pm 06-02-21 (1)

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A Pm 06-02-21 (1)

10-Open holes to .391" as per detail "D" Pm 06-02-21 (1)

11-Deburr Pm 06-02-21 (1)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M19100 BE 06-02-22 (1)

13-Grind welds flush as per Dwg D2750
BE 06-02-22 (1)

5.0	QC5/9	WELD INSPECTION

Comment: WELD INSPECTION DP 06-2-27 PD 06-02-27 (1)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 G.M. 06-02-25

7.0	D2739	350 I Beam

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2739	Web	B25540 Pm 06-02-27 (1)

Date: Monday, 1/16/2006 4:15:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511 **Part Number:** D350636014

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

8.0 D2743 Crossbolt Spacer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 D2743 Crossbolt spacer B24641 BE 06-02-28 (1)

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" Æ holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil PMC 06-02-27 (1)

2-Deburr and blow out all chips from inside of tube PMC 06-02-27 (1)

3-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 M19597 PMC 06-02-27 (1)
Sikaflex expire date: 06-06-18

4-Weld crossbolt spacers D2743 as per Dwg D2750and QSI 004
A/R Aluminum Rod ~~[illegible]~~ M19100 BE 06-02-28 (1)

5-Grind welds flush as per Dwg D2750 06-02-28 IT (1) BE

6-Spot face ground handling holes Æ0.750" (8 places) IT 06-02-28 (1) BE

7-Deburr holes IT 06-02-28 (1) BE

10.0 QC5/9 WELD INSPECTION (1)

Comment: Inspect weld and work to Step 20 06-03-01 06/03/02

11.0 POWDER COATING POWDER COATING

Comment: POWDER COATING
Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3 Q.M 06-03-14 (1)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION (1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
Inspect for foreign object per QSI 024 DL 06/03/14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:15:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511

Part Number: D350636014

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D27422	Blade Fitting, RH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, RH	24640 a.m 06-03-14

Seq. #:	Machine Or Operation:	Description :
14.0	AN835A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M 18576

Seq. #:	Machine Or Operation:	Description :
15.0	AN960JD816	1/2" washer,Alum

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M 6956

Seq. #:	Machine Or Operation:	Description :
16.0	MS21083N8	Nut

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19185

Seq. #:	Machine Or Operation:	Description :
17.0	D26483	Wearpad

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B 24843

Seq. #:	Machine Or Operation:	Description :
18.0	D265613	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B 25329

Date: Monday, 1/16/2006 4:15:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511
Part Number: D350636014

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	D265635	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B24148

Seq. #:	Machine Or Operation:	Description :
20.0	D2746	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B24149

Seq. #:	Machine Or Operation:	Description :
21.0	ALS41032225	Insert

Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 (or AKS4-1032-225) (or ALS7-1032-225) (or AKS7-1032-225)	Insert	M 1876

Seq. #:	Machine Or Operation:	Description :
22.0	AN960JD10L	Washer

Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M 19185

Seq. #:	Machine Or Operation:	Description :
23.0	AN35A	Bolt

Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M14826

A.M 06-03-15

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511

Part Number: D350636014

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	AN36A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

Seq. #:	Machine Or Operation:	Description :
25.0	D2745	Bushing

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B 25840

Seq. #:	Machine Or Operation:	Description :
26.0	AN644A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M 19185

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L6	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614

Seq. #:	Machine Or Operation:	Description :
28.0	AN36A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M 100274

A. m 06-03-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 1/16/2006 4:15:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511
Part Number: D350636014

Job Number:

Seq. #:	Machine Or Operation:	Description :
29.0	AN960JD10	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	~~M19255~~ 160660

Seq. #:	Machine Or Operation:	Description :
30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and séal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.
A/R Sikaflex-291 M19597
Sikaflex expire date: 06-18-06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.
A/R Sikaflex-291 M19597
Sikaflex expire date: 06-18-06

3-Install D2745 Bushing as per Dwg. D2750 Detail M a.m 06-03-14

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q a.m 06-03-14

Seq. #:	Machine Or Operation:	Description :
31.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP M 06 03 15

Seq. #:	Machine Or Operation:	Description :
32.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
33.0	D2741	Blade

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
1	D2741	Blade	B24750

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 26/03/17

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:15:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25511
Part Number: D350636014

Job Number:

Seq. #:	Machine Or Operation:	Description :
34.0	AN960JD816	1/2" washer,Alum

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

Seq. #:	Machine Or Operation:	Description :
35.0	MS21083N8	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
2	MS21083N8	Nut	M19099

Seq. #:	Machine Or Operation:	Description :
36.0	AN816A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN8-16A	Bolt	M5760

6/3/16

Seq. #:	Machine Or Operation:	Description :
37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS — SB 06/03/16

Seq. #:	Machine Or Operation:	Description :
38.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Package as per PPP D350-636-013 — REV D 6/3/16

Seq. #:	Machine Or Operation:	Description :
39.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21 — 06/03/17

Job Completion

06.03.17

Form: rprocess

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED KE	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740
C1	05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED

RELEASED 98.12.16 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
~~40~~ 38	~~40~~ 38	~~40~~ 38	~~40~~ 38	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
~~44~~ 42	~~44~~ 42	~~44~~ 42	~~44~~ 42	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
~~44~~ 42	~~44~~ 42	~~44~~ 42	~~44~~ 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE DEOs: DEO 4133 98.01.19 DS; DEO 4157 98.10.21 DS

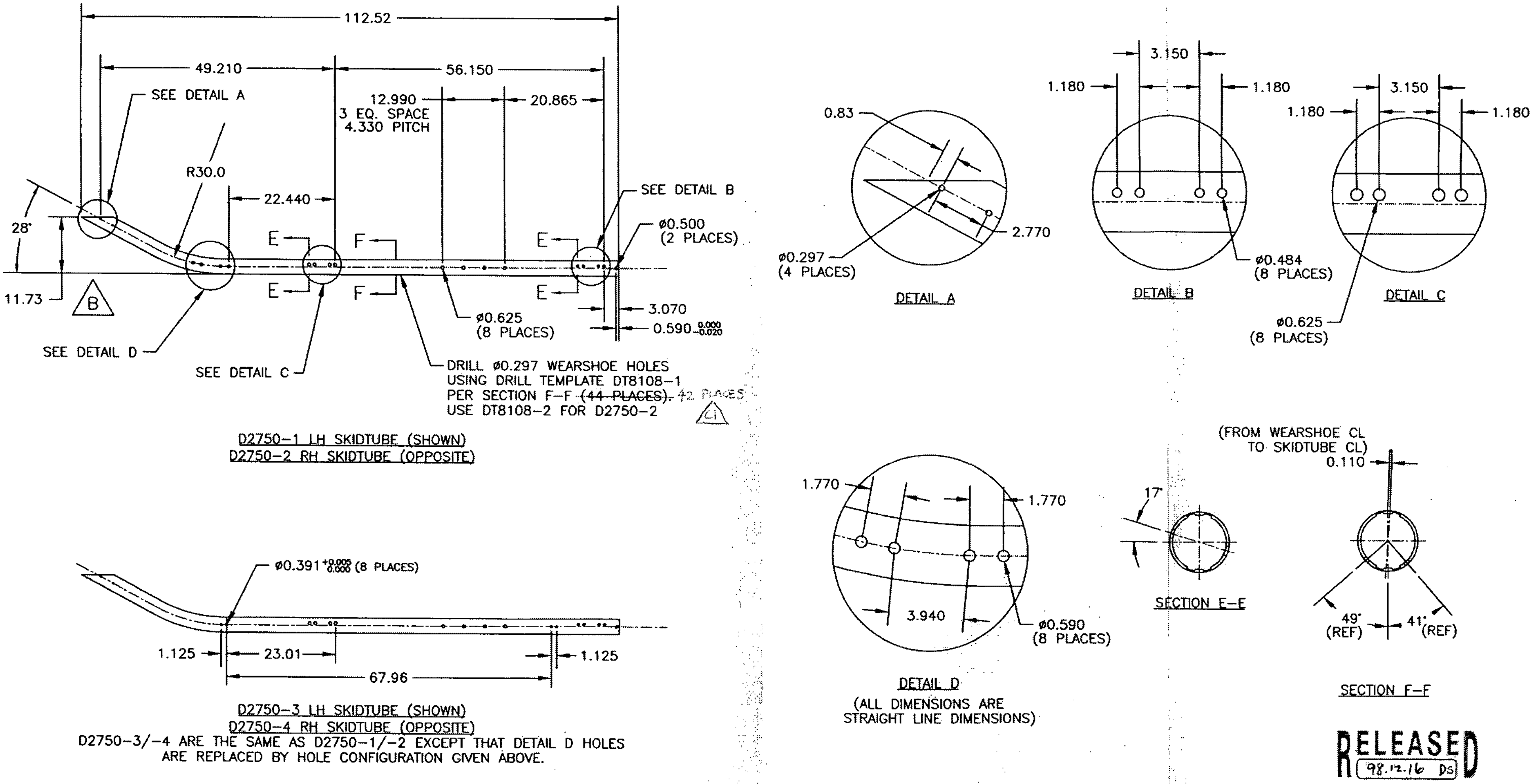
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

DART

GENERAL NOTES:

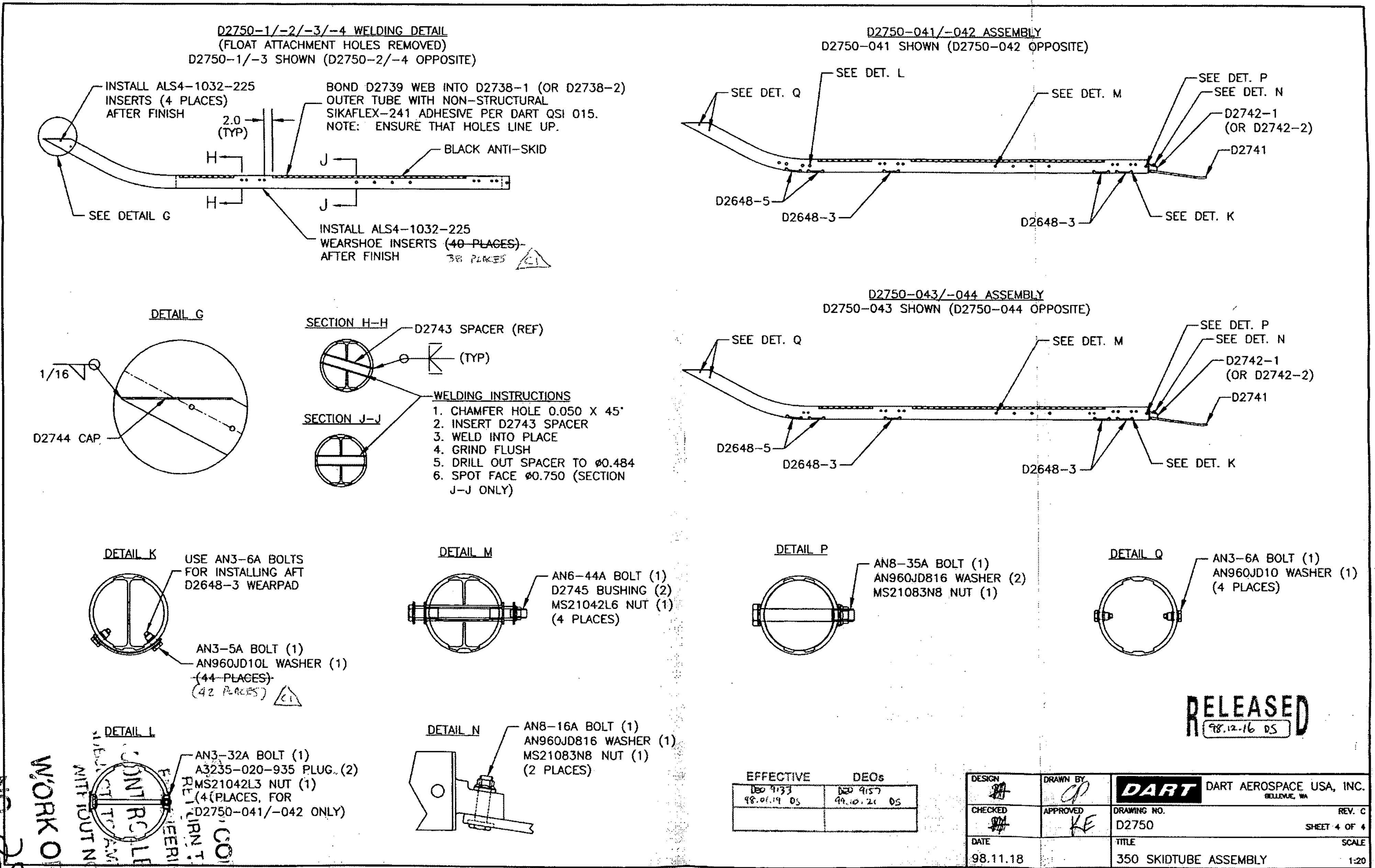
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
   ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS



EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.01.21 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2750	REV. C SHEET 3 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20



EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2750	REV. C SHEET 4 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20